

Work Order ID 54310



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December 7, 2009 3:08:29 PM

Item ID: D3767-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Rail



Cust Item ID:

Start Date: 07/12/2009 Start Qty: 20.00

Customer:

Required Date: 21/12/2009 Req'd Qty: 20.00



Reference:

Run Start

Approvals: Process Plan: PL Date: 07-12-11 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3767	Rev B

100



Small Fab

0.00

SAD 10-01-11

Opd 10/01/11

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3767 2-drill holes thru to finish size as per
dwg D3767 Using DT9410, Locate tube on stop labelled #2 and then drill holes
labelled #2 3-deburr

110



QC5- Inspect part completeness to step on W/O

0.00

→ S10.0.1.12

carlos
(x20)

QC

Memo

0.00

Quality Control

120



Chemical Conversion Coat per QSI005 4.1

0.00

Bl 10-01-12

(20) ✓

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54310

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Item ID: D3767-1

Accept



Setup Start



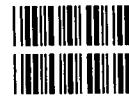
Revision ID:

Stop



Item Name: Upper Rail

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

M 10-01-12

(X20) Ø

140



Packaging

Packaging

Identify as per dwg & Stock Location: 254

0.00

10-1-12

WT SP

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/13

MF 10-1-12

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

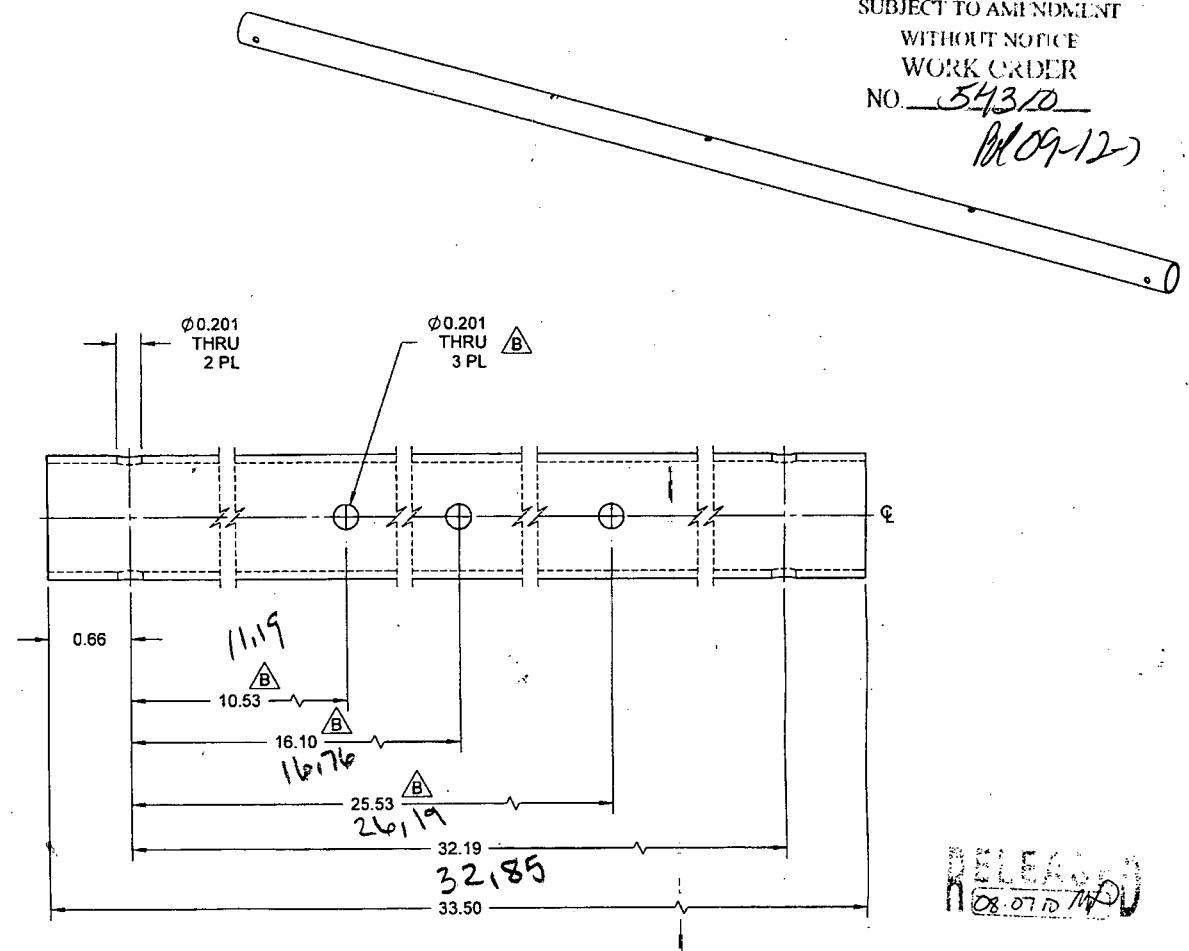
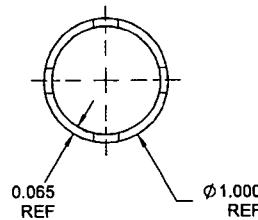
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 54310

(09-12)



B	CHANGE HOLE SIZE TO 0.201, SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10		HS	08.06.23
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3767	SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	UPPER RAIL	NTS	
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

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